

Patent Claims

1. A method for the production of hollow grinding bodies (9) for the comminution of grinding stock, comprising
5 a casting mold (1) with a cavity (2),

the arrangement of a casting core (4) in the cavity (2), so that a shell-like interspace (5) for casting
10 material is obtained,

the introduction of holding elements (6) for holding the casting core (4),

15 the application of a casing (71, 72, 73) onto the holding elements (6),

the pouring of the casting material into the interspace (5),
20 characterized in that,

at least in the region of the interspace (5) for the casing (71, 72, 73), a metallic material which fuses
25 with the casting material is used.
2. The method as claimed in claim 1, characterized in that the thickness of the metallic casing (71, 72, 73) is varied locally.
- 30 3. The method as claimed in one of the preceding claims, characterized in that the metallic casing (71, 72, 73) is applied over a length such that an excess length projecting into the region of the casting core (4) and/or of the casting mold (1) is obtained.
- 35 4. The method as claimed in claim 3, characterized in

that the excess length amounts to between one and two thirds of the diameter of the holding elements (6).

5. The method as claimed in one of the preceding claims,
5 characterized in that an insulating intermediate layer (8) is produced under the metallic casing (71, 72, 73).
6. The method as claimed in claim 5, characterized in
10 that an air layer is used as an insulating intermediate layer.
7. The method as claimed in one of the preceding claims,
15 characterized in that structural steel or boiler plate is used as metallic material.
8. The method as claimed in one of the preceding claims,
20 characterized in that spherical grinding bodies are produced.
9. A grinding body for the comminution of grinding
stock, which is in the form of a hollow body and has
in its shell orifices (11) for holding elements (6)
for holding a casting core (4), casings (71, 72, 73)
25 of the holding elements (6) being fused in so as to border the orifices (10),
characterized in that
30 the fused-in casings (10) consist of metallic material.
10. The grinding body as claimed in claim 9, character-
ized in that the thickness of the casing (71, 72, 73)
35 is local.
11. The grinding body as claimed in claim 9 or 10, char-

acterized in that an intermediate layer (8) is arranged between the casing (71, 72, 73) and the holding elements (6).

- 5 12. The grinding body as claimed in either one of claims
 10 and 11, characterized in that structural steel or
 boiler plate is used as metallic material.
- 10 13. The grinding body as claimed in one of claims 9 to
 12, characterized in that it is in the form of a
 grinding sphere (9).